






Work Order ID 63722

Thursday, November 11, 2010 8:01:25 AM


Page 1

Item ID:	D4148-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Stud Receiver, Lower				Stop	
Start Date:	11/11/2010	Start Qty:	10.00	Cust Item ID:		
Required Date:	11/19/2010	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>mtf</u>	Date:	<u>10-11-11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4148	c

100	Cut blanks as per folio	0.00							
									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	5.350" LONG								

B.A 10/11/23

6 0

110		0.00							
									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLI FA944 AND DWG								
	FOLIO REV: <u>HAAS C</u>								
	DWG REV: <u>C</u>								
	DEBURR								

B.A 10/11/23

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

Revision ID:

Item Name: Stud Receiver, Lower

Start Date: 11/11/2010 Start Qty: 10.00

Required Date: 11/19/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

A.A 10/11/24

6

Ø

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SA 10/11/25

6

Ø

Quality Control

170

Identify as per dwg & Stock Location: 5T132 0.00

Packaging

Memo

0.00

Packaging

C. R. 10/25/10

W/O:		WORK ORDER CHANGES					
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Setup Start

Revision ID:

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Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/26 [Signature]
MF
10-11-25

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 11, 2010 8:01:25 AM

Page 1

Work Order ID: 63722



Parent Item: D4148-3



Parent Item Name: Stud Receiver, Lower

Start Date: 11/11/2010

Required Date: 11/19/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X03.000		Purchased	No			100	f	9.6000	0.48	4.8			

303 BAR 1" X 3'

Location

Loc Qty

Loc Code

MAT

9.6

✓ 115555

9.6

2.6950 ft

B.A 10/11/23

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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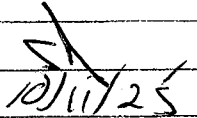
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order: 63722
Description: STUD RECEIVER, LOWER		Part Number: D4148-3
Inspection Dwg: D4148 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.129	+ .005/- .001	Ø 0.129	✓		Vern	GA-01
0.375	+/- .010	0.378	✓		"	"
1.00	+/- .030	1.000	✓		"	"
Ø 0.50	+ .006/- .001	0.501	✓		"	"
0.375	+/- .010	0.377	✓		"	"
0.91	+/- .030	0.911	✓		"	"
1.982	+/- .010	1.982	✓		"	"
0.919	+/- .010	0.922	✓		H-G	31006
1.000	+/- .010	1.001	✓		Vern	GA-01
3.000	+/- .010	3.000	✓		"	"
0.368	+/- .010	0.368	✓		"	"
3.76	+/- .030	3.764	✓		H-G	31006
0.735	+0.000/-0.010	0.727	✓		Vern	GA-01
Ø 0.453	+0.010/-0.000	Ø 0.4565	✓		"	"
Ø 0.250	+ .005/- .001	Ø 0.251	✓		"	"
0.060 X 45°	+/- .030	0.060 X 45°	✓		"	"
0.80	+/- .030	0.803	✓		"	"
0.625	+/- .010	0.625	✓		"	"
0.89	+/- .030	0.891	✓		H-G	31006
2.12	+/- .030	2.112	✓		Vern	GA-01

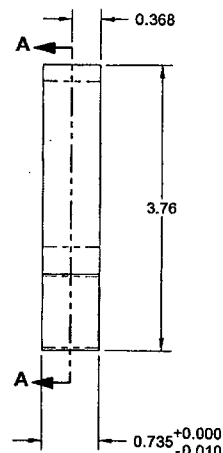
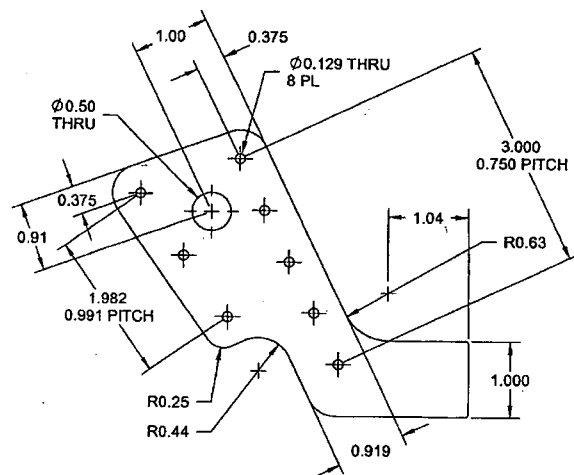
Measured by: B.A	Audited by: 	Preliminary Approval:
Date: 10/11/24	Date: 10/11/25	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

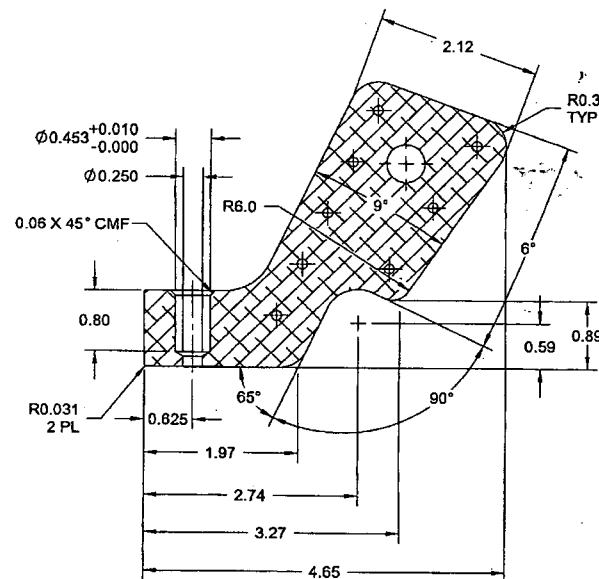
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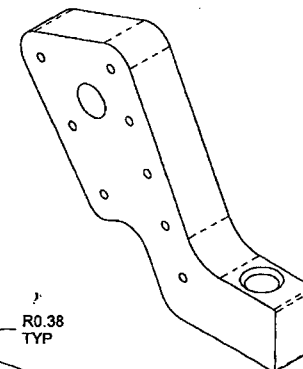
63720



D4148-3 STUD RECEIVER LOWER



SECTION A-A



RELEASED
2010-10-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
DATE	10.10.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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